

Date: Friday, 25/07/2008 4:20:57 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BRACKET
<b>Job Number</b>	: 40766		
<b>Estimate Number</b>	: 13514		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D21971
<b>This Issue</b>	: 25/07/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2197 REV C
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	:	<b>Drawing Revision</b>	: C
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 20/08/2008
<b>Checked &amp; Approved By</b>	: <u>JUD 08.7.25</u>	<b>Qty:</b>	2 Um: Each
<b>Comment</b>	: Est Rev:A / 08-07-24 new issue ec verified by:dd		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 0.1457 sf(s)/Unit Total : 0.2915 sf(s)

304 SS Sheet 0.063" thick

batch: 108724 IB 8-8-20

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2196

Dwg Rev: C

Prog Rev: C

IB 8-8-20

(3)

2-Deburr if necessary

IB 8-8-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-8-20

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/08/20

(13)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Bend as per dwg D2196

SB 09/08/25

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:57 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40766

Part Number: D21971

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/25 (+3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock  
Location: 19

8/8/25

(3X)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26 HJ

Job Completion



U 08-08-26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

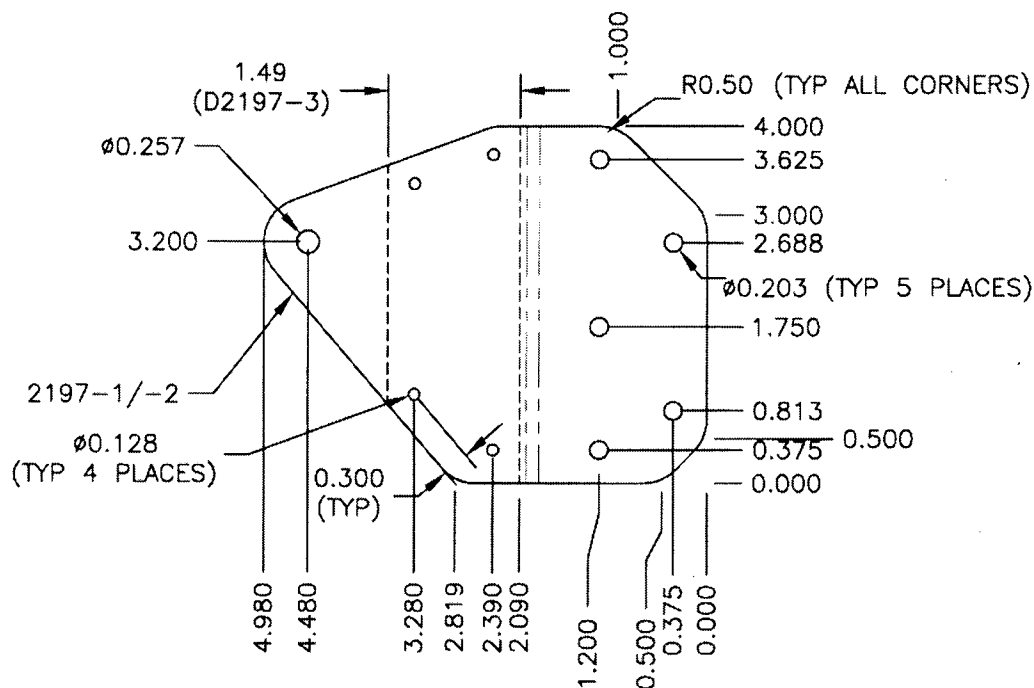
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2197	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	

D2197-1/-2/-3  
FLAT PATTERN



D2197-1/-2

- 1) MATERIAL: AISI 304/316 S.S.  
0.064" THICK (M304S16GA)

D2197-3

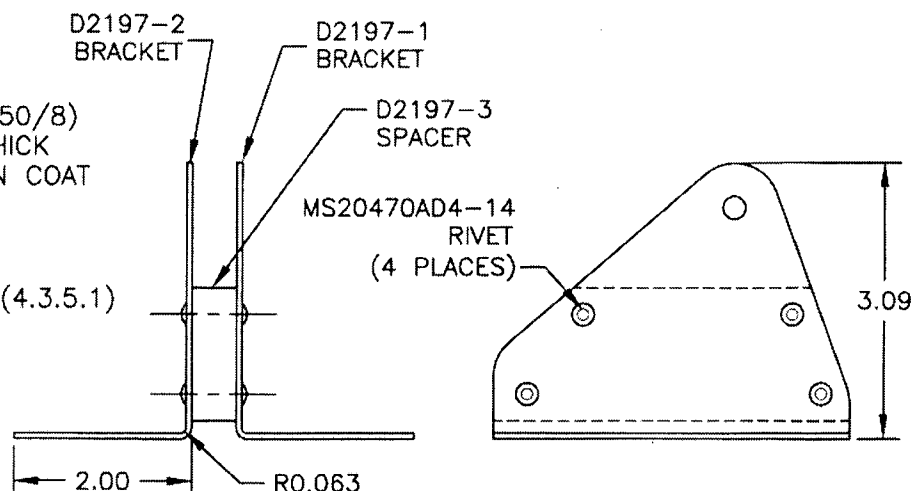
- 2) MATERIAL: 5052H32 (QQ-A-250/8)  
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1

D2197 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)  
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2197 BRACKET  
(ASSEMBLY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84872

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40766
<b>Description:</b> BRACKET		<b>Part Number:</b> 02197-1
<b>Inspection Dwg:</b> D2197-1 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.131	*			
Ø .203	+ .005 - .001	.207	*			
Ø .257	+ .006 - .001	.261	*			
.300	+/- .010	.298	*			
.375	+/- .010	.373	*			
.500	+/- .010	.500	*			
1.200	+/- .010	1.201	*			
2.390	+/- .010	2.390	*			
3.280	+/- .010	3.283	*			
4.480	+/- .010	4.480	*			
4.980	+/- .010	4.983	X			
.500	+/- .010	.500	X			
.813	+/- .010	.813	*			
1.750	+/- .010	1.752	*			
2.688	+/- .010	2.690	*			
3.625	+/- .010	3.626	X			
4.000	+/- .010	4.004	*			
.063	+/- .010	.060	X			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b> A
<b>Date:</b> 8-8-20	<b>Date:</b> 08/08/20	<b>Date:</b> A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	